



Dart Aerospace Ltd.
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K6A 1K7
Canada

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010759

repaired

split

3

D5359-041
Job Sheet 196425



Part No: D5359-041

Job Qty: 4 pcs

DAS
21
9-89

Part Name: Strut Assembly, LH/RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF 19-640 DWG REV B SHEETS 1,2,3 IPP Rev: A RQ 16.03.23 Verified by: DD IPP REV:B 17.01.20 AS
PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Small Fab - 1	4 pcs	7/12/19		0.00	3.15	Small Fab - 1			DAS 71 9-89
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
		4 pcs	7/12/19		0.50	3.85	Skid tubes - Bend - B4B			19-6-21
		4 pcs	7/12/19		0.00	3.15	Small Fab - 1 - B4B		DAS 71 9-89	19-6-25
							Small Fab - 2 - B4B			
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
		4 pcs	7/12/19		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			

Op No: 062719

Revision: 062719

Inspector: Various STC's

Exp Date: Various STC's

Instructions: Various STC's

Part: D5359 - 041

Job No: 196425

Serial No/Batch: S192717

Container No: S192717

AEROSPACE

DART

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DART
AEROSPACE

Container No: S192717

Part: D5359-041

Job No: 196425

Serial No/Batch: S192717

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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Date: 06/21/19

NCR: 19-7282

				QC 5 - 30		
				QC 5 - 40	JUN 27 2019	
130	Conventional Mill - 1 - B4B	4 pcs	7/12/19	0.00 4.00	Conventional Mill - 1 - B4B	///
					Conventional Mill - 2 - B4B	
140	QC 2	4 pcs	7/12/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	11/19/128
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
150	QC 8	4 pcs	7/12/19	0.00 0.00	QC 8 - 12	M/19/07/02
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	

Plex 6/21/19 9:55 AM dart.lacelle.linda

					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
160 Powdercoat - 2 White G(S)- B4B	4 pcs	7/12/19	0.00 0.75		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					QC 3 - 10	
170 QC 3	4 pcs	7/12/19	0.00 0.00		QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
180 Small Fab - 3 - B4B	4 pcs	7/12/19	0.00 3.15		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
200 QC 5	4 pcs	7/12/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
210 Small Fab - 4 - B4B	4 pcs	7/12/19	0.00 3.15		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	

220 QC 5	4 pcs	7/12/19	0.00 0.00	Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS
				QC 5 - 30	40
				QC 5 - 40	JUL 05 2019 9-89
230 Packaging 3-1 - Stock - B4B	4 pcs	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	pc 57369
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
240 QC 21 - SA	4 pcs	7/12/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89 JUL 05 2019
				QC 21 - SA - 53	

Part Op 110 - Small Fab - 1- CUT SQUARE TUBING AT 48.00"
Descriptions: 112 - CNC Alpha 160 Bender - 1- FORM TUBING AS PER DWG USING DT10300 USING CNC BENDER 100 AND FOLIO 32 BEND PROG D5359.
114 - Small Fab - 1- TRIM OFF EXTRA MATERIAL USING DT10300 2- DEBURR
120 - QC5- Inspect part completeness to step on W/O
130 - 1- DRILL 0.194" HOLES THRU 1 WALL ONLY (4PL.) AS PER DWG. (SHEET 3) 2- INSERT D5359-3 INTO TUBING AND USE AS A GUIDE TO FINISH TRANSFER DRILLING HOLE THRU. MODIFY D5359-3 IF NEEDED SO THAT IT FIT IN TUBING. 3- INSERT (AN3) BOLT TO ENSURE PROPER FIT THRU. 4- DRILL WITNESS HOLES TRUE BOTH WALLS AS PER DWG, SHEET 2, DETAIL A AND VIEW B-B
140 - QC2- Inspect parts off machine FAI/FAIB
150 - QC8- Inspect parts - second check
160 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
170 - QC3- Inspect Part Finish
180 - Small Fab - 1- ASSEMBLE INSERT IN TUBE AS PER DWG ***DO NOT INSTALL CLEVIS***
200 - QC5- Inspect part completeness to step on W/O
210 - Small Fab - ASSEMBLE CLEVIS AND NUT AS PER DWG
220 - QC5- Inspect part completeness to step on W/O
230 - Identify as per dwg & Stock Location: _____
240 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	13.3360 ft (3.334 ea)	110-Small Fab - 1	5186641
D5359-3	Insert	8 pcs (2 ea)	130-Conventional Mill - 1 - B4B	5193169
AN3CH11A	Bolt (Drilled Head)	8 Ea (2 ea) ST319	180-Small Fab - 3 - B4B	8016871
AN3CH12A	Bolt (Drilled Head)	8 Ea (2 ea) ST319	180-Small Fab - 3 - B4B	8080446
MS21043-3	Nut	16 Ea (4 ea) ST302	180-Small Fab - 3 - B4B	8181801
NAS1149C0363R	Washer (AN960C10)	40 Ea (10 ea) ST266	180-Small Fab - 3 - B4B	8181483
D2690-6	Lanyard	8 pcs (2 ea) ST009	210-Small Fab - 4 - B4B	8187668
D5359-5	Clevis, Aircraft End	4 pcs (1 ea) GA132	210-Small Fab - 4 - B4B	8019965
D5359-7	Clevis, Basket End	4 pcs (1 ea) GA132	210-Small Fab - 4 - B4B	814211
MS17984-C405	Pin, Quick Release	4 Ea (1 ea) ST315	210-Small Fab - 4 - B4B	1x5183008 - 3x8195831
MS17984-C608	Pin, Quick Release	4 Ea (1 ea) OVERLOS	210-Small Fab - 4 - B4B	8017837
NAS509-6C	Nut	8 Ea (2 ea) ST331	210-Small Fab - 4 - B4B	4x806878 - 3xFT129913

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	M304TS0.750W.049	13	130	0
130-Conventional Mill - 1 - B4B	D5359-3	8	0	0
180-Small Fab - 3 - B4B	AN3CH11A	8	16	0
	AN3CH12A	8	20	0
	MS21043-3	16	1,076	0
	NAS1149C0363R	40	740	0
210-Small Fab - 4 - B4B	D2690-6	8	111	0
	D5359-5	4	8	0
	D5359-7	4	4	0
	MS17984-C405	4	9	0
	MS17984-C608	4	10	0
	NAS509-6C	8	7	0

Part Specifications

Specifications could not be found.

ml
Jul 9, 2019

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7287

Route update only ☐



Job: 196425		DISPOSITION		DEPARTMENT/PROCESS				Engineering	
Part No. D5359-041		Rework ☒ Scrap ☐ Use-as-is ☐		Cross tube ☒ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042) DAS 51 9-89 SAT 12/06/17		Completed By DAS 51 9-89 SPO 19/06/17	
Description Work Order Deviation		Disposition		Lead hand / Supervisor Suf 19/07/02		QC / QA Coordinator DAS 40 9-89 JUL 05 2019			
D5359-3 insert will not install in tubing (tubing is too small). Tubing should be 0.75 x 0.75 x 0.049, OD should be ±0.005 per spec. ASTM A269. However mat is 0.749 x 0.741 x 0.049 (out of spec).		Face D5359-3 evenly to allow fit in tubing. Face both sides evenly to maintain center of tubing hole. Part is nominally 0.650 x 0.650 Recommend 0.640 x 0.647							
Root Cause		FAULT CATEGORY		Positioned Wrong					
Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	

